

Work Order ID=76272
Tuesday, November 08, 2011 1:27:55 PM

Page 1

Accept

Setup Start

NS1

Stop

NS2

8

Cust Item ID:

8

Customer:

Reference:

Run Start

NR1

Date: 11/11/08

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr	
D3637	Rev B	

0.00

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

304.080

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76272

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Item ID: D3637-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 11/8/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 8.00 ***8*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3637	0.00 0.00				(12)			
140 *140* Small Fab Small Fab	Small Fab Memo 1- drill holes as per dwg using DT89792-C'Sink as per Dwg D3637 3- Install Nut plate as per Dwg D3637	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

SB 11/12/13

11/12/21 (12)

5/12/21

(412)

W/O:		WORK ORDER CHANGES					
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Tuesday, November 08, 2011 1:27:55 PM

Item ID: D3637-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 11/8/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>245</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/12/22 *[Signature]*
 ME
 11-12-22

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 76272

76272

Parent Item: D3637-041

D3637-041

Parent Item Name: Bracket Assembly

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 *MS20426AD3-3* Rivet		Purchased	No			100	Each	4,105.000	2	16			
				<u>Location</u>				<u>Loc Qty</u>					
				ST316				4105					
				119109				3000					
				19099				1105					
M304S14GA *M304S14GA* 304SS sheet .080		Purchased	No			140	sf	120.1000	0.09	0.757895			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT020				120.1					
				117933				24.1					
				119276				96					
MS21059L4 *MS21059L4* Nutplate		Purchased	No			140	Each	59.0000	1	8			
				<u>Location</u>				<u>Loc Qty</u>					
				ST301				59					
				117887				9					
				118612				50					

**

**

**

11/12/21

24
0.757895
11-11-9

117933

11/12/21

12

12

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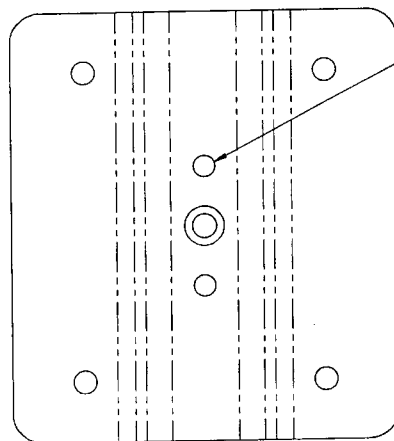
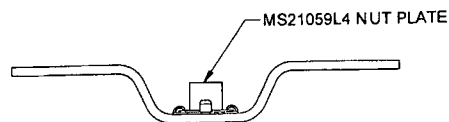
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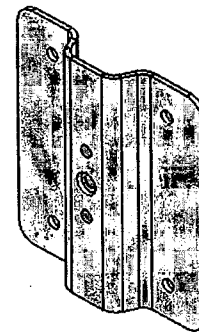
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MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76272
R11-11-08

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	EP		
MFG. APPR.	EP		
APPROVED	EP		
DE APPR.	EP		
DATE	07.12.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3637 TITLE BRACKET SCALE 1:1 REV. B SHEET 1 OF 3 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

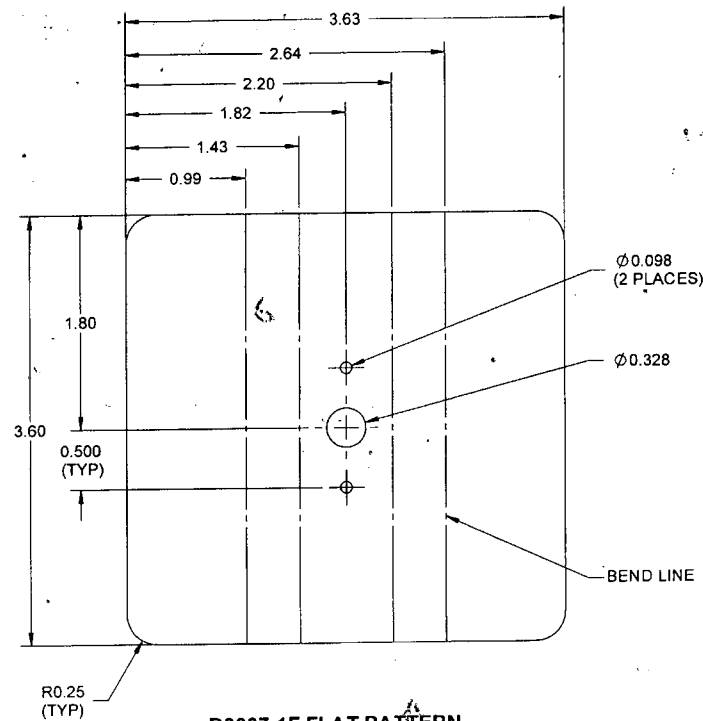
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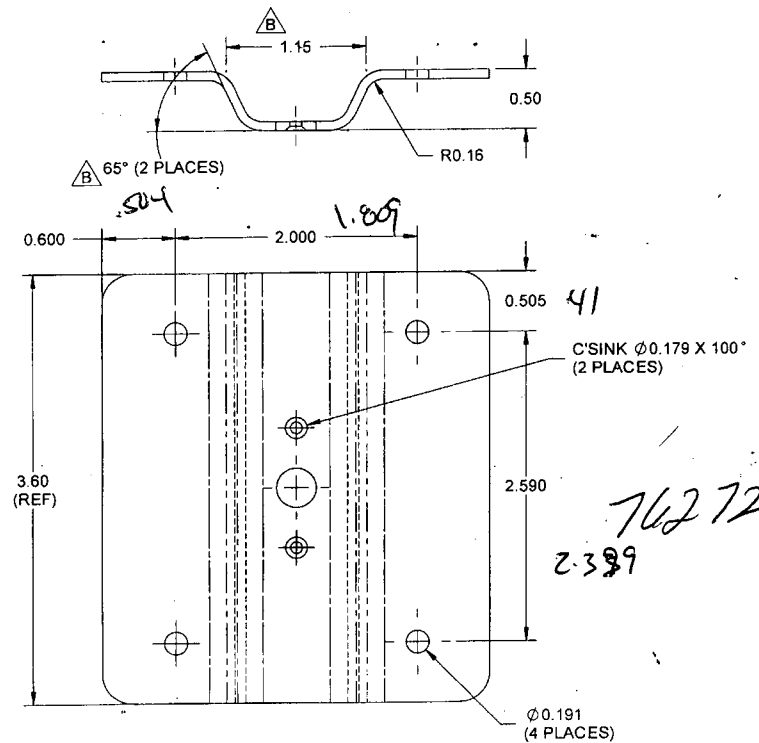
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D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



- D3637-1 NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	JS	D3637	SHEET 2 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
08-22-09

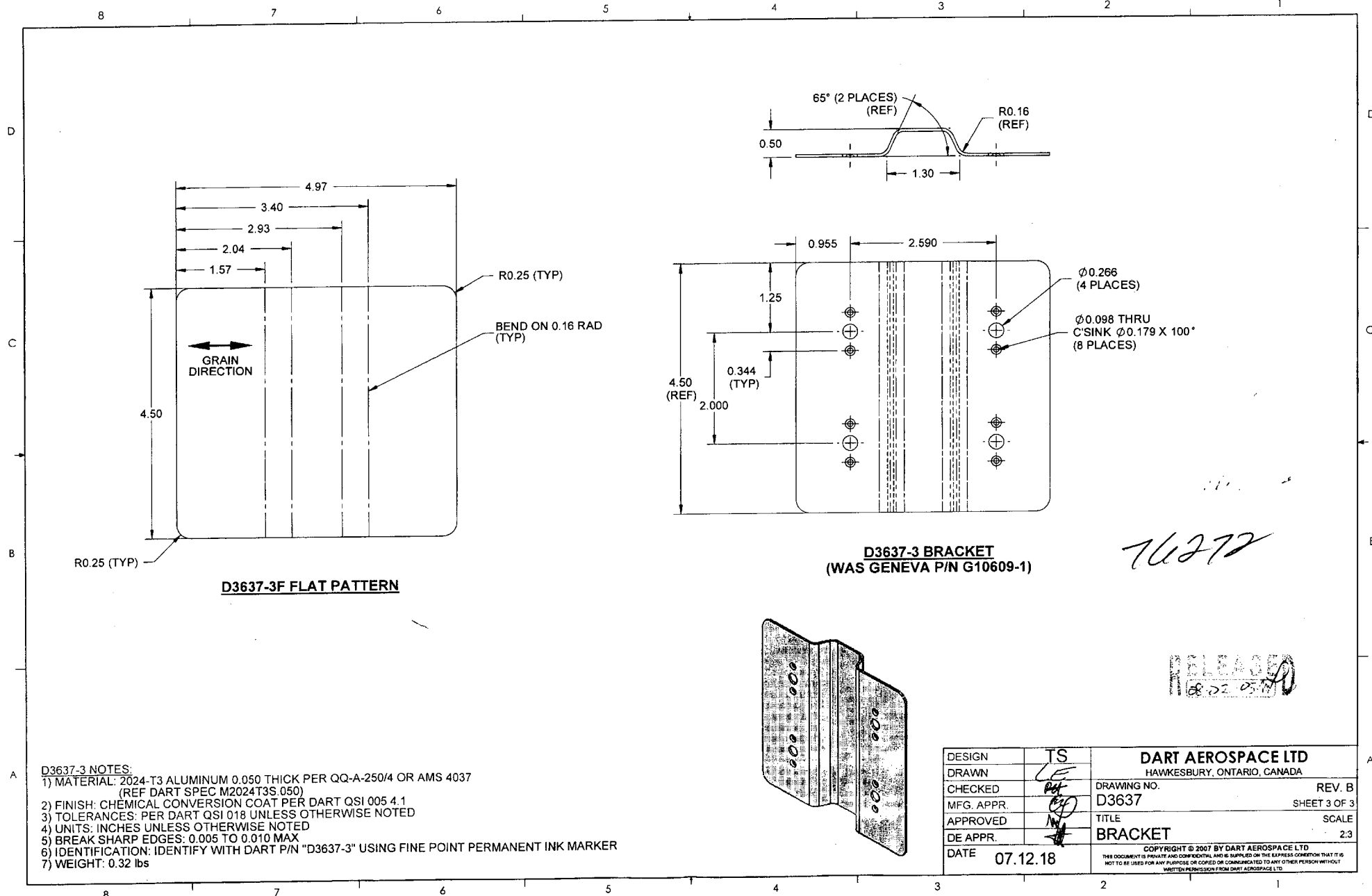
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